

Work Order ID 63763

Friday, November 12, 2010 11:58:43 AM



LH

Page 1

Item ID: D4278-045

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Rib Assembly, Fwd Cham

Start Date: 11/15/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 11/16/2010 Req'd Qty: 2.00



Customer:

Reference:



PRELIMINARY ISSUE

Approvals: Process Plan: *MWP*

Date: 10-11-12

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr | MATERIAL CERTIFICATION REQD UPON DELIVERY |
|----------|--------------|--|
| D4278 | PA1 | |

100 Weld per dwg A/R S.S. rod Batch: *11585* 0.00

Large Fab

Memo

0.00

Large Fab

1- Assemble ribs and weld as per dwg DT

PL 10-11-16 *2x*

110 QC9- Inspect visual per QSI004 Fusion Welds 0.00



QC

Memo

0.00

Quality Control

PL 10-11-16 *2* *8*

120 QC5- Inspect part completeness to step on W/O 0.00



QC

Memo

0.00

Quality Control

2x 10-11-17
PA1

Work Order ID 63763

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Customer:

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
Description

130

Identify as per dwg & Stock Location: B/CSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Packaging

Packaging

Memo

STOCK IN BASKET CELL

140

QC21- Final Inspection - Work Order Release



QC

Quality Control

Memo

0.00

0.00

Q
PL
10-11-17
D. test RopPA1 RevA
10.11.22
PL
10-11-17
(2)

POSITIVE RECALL

EFFECTIVE _____ AUTH _____

RELEASED _____ DATE _____

Picklist Print

Page 1

Friday, November 12, 2010 11:58:43 AM

Work Order ID: 63763



Parent Item: D4278-045



Parent Item Name: Rib Assembly, Fwd Cham

Start Date: 11/15/2010

Required Date: 11/16/2010

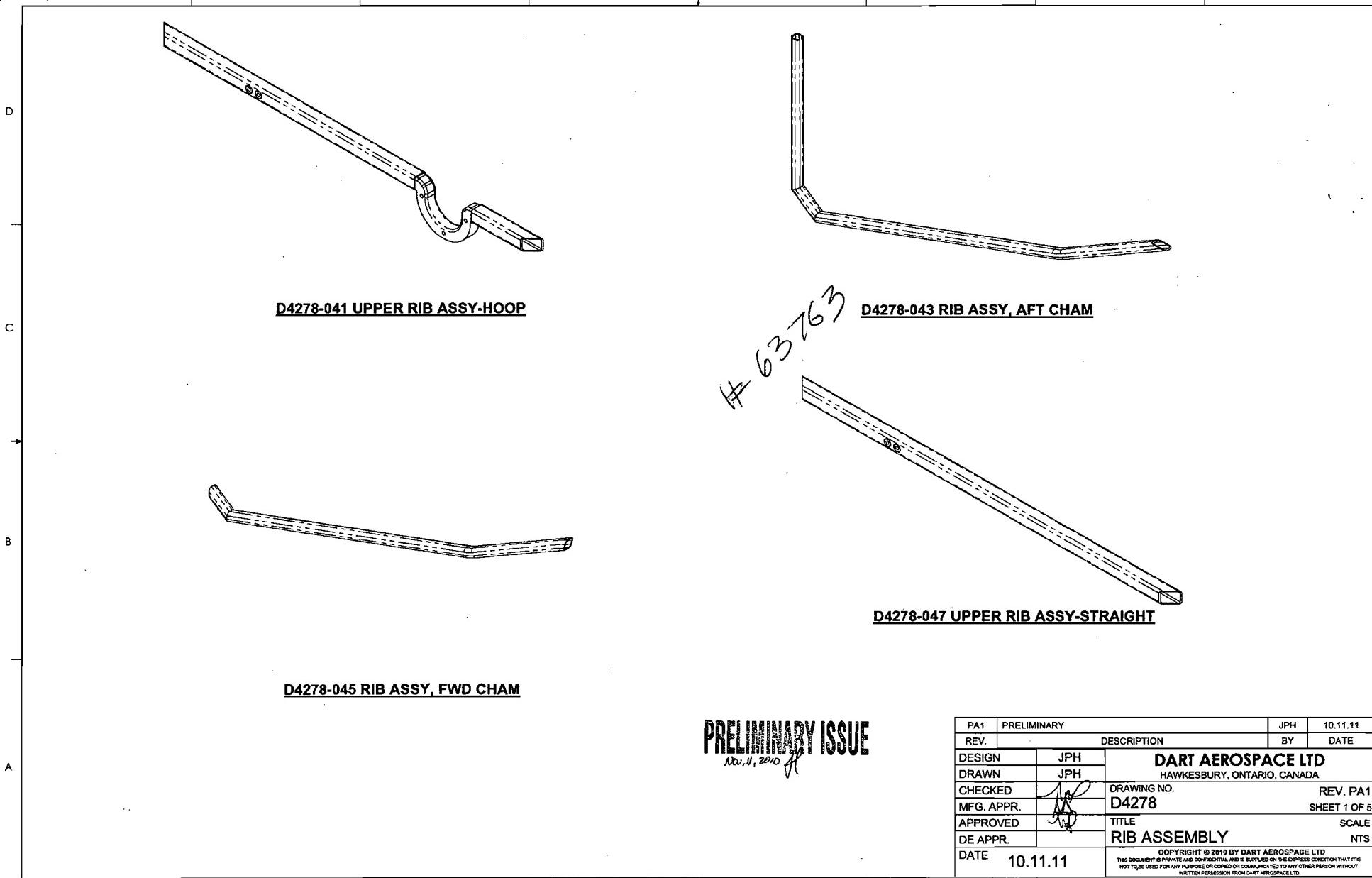
Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.11.12 new issue DD verf:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D4277-11 | | Manufactured | | No | | 100 | Each | 0.0000 | 1 | 2 | | B63777 → (2) | |
| Rib D4277-7 | | Manufactured | | No | | 100 | Each | 0.0000 | 1 | 2 | | B63776 → (2) | |

8 7 6 5 4 3 2 1



| | | | |
|------------|-------------|--|----------|
| PA1 | PRELIMINARY | JPH | 10.11.11 |
| REV. | | DESCRIPTION | BY DATE |
| DESIGN | JPH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | JPH | | |
| CHECKED | | | |
| MFG. APPR. | | | |
| APPROVED | | REV. PA1 | |
| DE APPR. | | D4278 SHEET 1 OF 5 | |
| DATE | 10.11.11 | TITLE | SCALE |
| | | RIB ASSEMBLY | NTS |

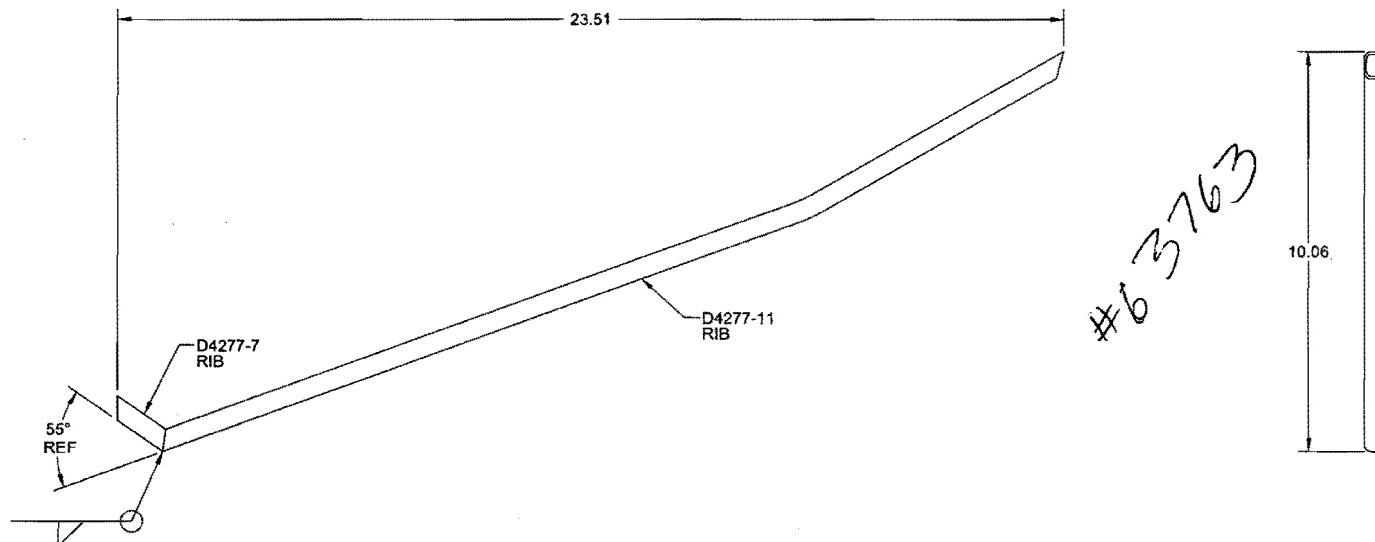
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8 7 6 5 4 3 2 1

| ITEM | QTY | PART NUMBER | DESCRIPTION |
|------|------|-------------|-----------------------|
| | -045 | D4278-045 | RIB ASSY, FWD CHAM |
| 1 | 1 | D4277-7 | MID CORNER RIB, NOTCH |
| 2 | 1 | D4277-11 | MID DIAG RIB |

D

D



D4278-045 RIB ASSY, FWD CHAM

A

A

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.57 lbs
- 8) WELD PER DART QSI 004.

PRELIMINARY ISSUE

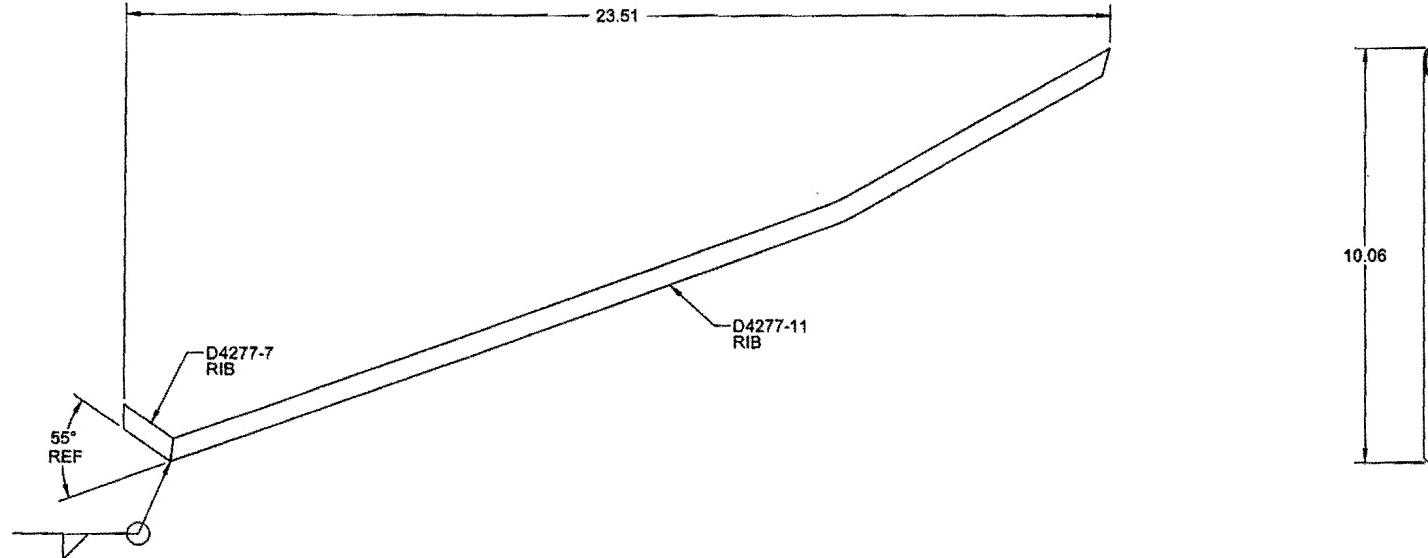
Nov 11, 2010 JH

| | | |
|------------|--------------------|--|
| DESIGN | JPH | DART AEROSPACE LTD |
| DRAWN | JPH | HAWKESBURY, ONTARIO, CANADA |
| CHECKED | <i>[Signature]</i> | DRAWING NO. REV. PA1 |
| MFG. APPR. | <i>[Signature]</i> | D4278 SHEET 4 OF 5 |
| APPROVED | <i>[Signature]</i> | TITLE SCALE |
| DE APPR. | <i>[Signature]</i> | RIB ASSEMBLY NTS |
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8 7 6 5 4 3 2 1

| | | |
|---|-----------|-------------------------------|
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D

D4278-045 RIB ASSY, FWD CHAM

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8 7 6 5 4 3 2 1

| DESIGN | JPH | DART AEROSPACE LTD | |
|------------|----------|-----------------------------|--------------|
| DRAWN | JPH | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. A |
| | | D4278 | SHEET 4 OF 5 |
| MFG. APPR. | | TITLE | SCALE |
| APPROVED | | RIB ASSEMBLY | NTS |
| DE APPR. | | | |
| DATE | 10.11.25 | | |

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